



Dart Hawkesbury
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D5159-1
Job Sheet 168458



Part No: D5159-1

Job Qty: 4 ea

Part Name: Rib



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/14/17

Job Tracking No:

Due Date: 11/27/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		11/25/17	0.00	0.00	Start Up Container		J.C.-L. 17-11-23
110	Cold Saw	4 pcs		11/25/17	0.00	0.62	Cold Saw		J.C.-L. 17-11-23
120	Mill Conv	4 pcs		11/25/17	0.00	5.48	Mill Conv 1		J.C.-L. 17-11-23
130	QC	4 pcs		11/25/17	0.00	0.00	QC2		J.C.-L. 17-11-23
140	QC	4 pcs		11/25/17	0.00	0.00	QC8		H.A. 17-11-27
150	Powdercoat	4 pcs		11/27/17	0.00	0.08	Powdercoat3		BK 17-11-28
160	QC	4 pcs		11/27/17	0.00	0.00	QC3		JP
170	Packaging	4 pcs		11/27/17	0.00	0.00	Packaging3		JP
180	QC21-SA	4 Ea		11/27/17	0.00	0.00	QC21		JP

Part Op 110 - CUT TO BLANK

Descriptions: 120 - DRILL HOLES AND MILL ENDS AS PER DWG ***ENSURE MATERIAL SEAM IS AT THE BOTTOM OF THE PART WHERE THERE IS NO HOLES***

150 - START TIME: 4:55 ON: 7:30 P.F. FINISH: 5:25

M 136320

NOV 29 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304TS0.750W.049	5	1,540	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Rib	14.700Inches $\pm$ 0.030	14.730 14.670		
2	Rib	12.790Inches $\pm$ 0.030	12.820 12.760		
3	Rib	0.950Inches $\pm$ 0.010	0.960 0.940		
4	Rib	0.266Inches $\pm$ 0.010	0.276 0.256		
5	Rib	0.297Inches $\pm$ 0.010	0.307 0.287		
6	Rib	0.400Inches $\pm$ 0.030	0.430 0.370		
7	Rib	1.000Inches $\pm$ 0.010	1.010 0.990		
8	Rib	3.000Inches $\pm$ 0.010	3.010		

			2.990	
9	Rib	2.000Inches $\pm$ 0.010	2.010 1.990	
10	Rib	2.000Inches $\pm$ 0.010	2.010 1.990	
11	Rib	3.000Inches $\pm$ 0.010	3.010 2.990	
12	Rib	1.000Inches $\pm$ 0.010	1.010 0.990	
13	Rib	0.129Inches + 0.005 - 0.001	0.134 0.128	
14	Rib	2.440Inches $\pm$ 0.030	2.470 2.410	
15	Rib	2.625Inches $\pm$ 0.010	2.635 2.615	
16	Rib	0.129Inches + 0.005 - 0.001	0.134 0.128	
17	Rib	0.350Inches $\pm$ 0.030	0.380 0.320	Radius

Plex 11/14/17 4:02 PM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							